

Work Order ID 126698

126698

Page 1

Monday, November 24, 2014 8:00:02 AM

Item ID: D2435

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw

Start Date: 11/24/2014 Start Qty: 12.00

12

Cust Item ID:

Required Date: 11/24/2014 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: MLS Date: 14-11-24

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2435

Rev E1

120

0.00

120

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

CUT BLANK AS PER FILE D2435

OHmw 1

12

0

DAS

23

9-89

14-11-27

130

0.00

130

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio FA789 and Dwg D2435 Identify as D2435
3-Deburr

12

1

DAS

37

9-89

15.01.06

140

QC2- Inspect parts off machine FAI/FAIB

0.00

140

QC

Memo

0.00

Quality Control

12

1

DAS

37

9-89

15.01.06

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

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Stop ***NS2***

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Required Date: 11/24/2014 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC8- Inspect parts - second check	0.00							
150									
QC	Memo	0.00							
Quality Control									
151	Identify as per dwg & Stock Location: _____	0.00							
151									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

encl 15/01/08

12

PP 126698

12

JAN 26 2015

DAS

15/1/28

1-27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Monday, November 24, 2014 8:00:08 AM

Page 1

Work Order ID: 126698

126698

Parent Item: D2435

D2435

Parent Item Name: Bearpaw

Start Date: 11/24/2014

Required Date: 11/24/2014

Start Qty: 12.00

Required Qty: 12.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	434.7000	3.2	39			DAS 23 9-89

MIJHMWB10

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

**

14-11-27

Location

Loc Qty

Loc Code

MAT014

296.3

m128267

41

m128668

255.3

128668.

TPI

138.4

m130421

138.4

DQA: _____ Date: _____



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DART AEROSPACE LTD		Work Order: 126698
Description: Bearpaw		Part Number: D2435
Inspection Dwg: D2435	Rev: E1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.0625	✓		DR16	8" VERN
B	5.500	+/-0.030	5.499	✓			
C	0.200	+/-0.030	.199	✓			
D	R0.250	+/-0.030	.250	✓			
E	0.250	+/-0.010	.250	✓			
F	0.625	+/-0.030	.625	✓			
G	0.25 x 45°	+/-0.030	.250	✓			
H	0.375	+/-0.010	.375	✓			
I	19.000	+/-0.030	19.00	✓			
J	0.950	+0.030/-0.010	.948	✓		TAPE MEASURE 8" VERN DR16	
K	Ø0.260	+0.005/-0.000	.260	✓			
L	Ø0.930	+/-0.030	.926	✓			
M	0.30	+0.030/-0.000	.310	✓			
N	0.375	+/-0.030	.375	✓			
O	7.375	+/-0.030	7.375	✓			
P	4.250	+/-0.010	4.250	✓			
Q	2.000	+/-0.030	2.006	✓			
R	9.000	+/-0.010	9.000	✓		TAPE MEASURE	
S	15.750	+/-0.030	15.750	✓		TAPE MEASURE	

Measured by: 37		Audited by: [Signature]		Prototype Approval: N/A	
Date: 15-01-06		Date: 15/01/08		Date:	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10007	KJ/RF	[Signature]

DQA: _____ Date: _____



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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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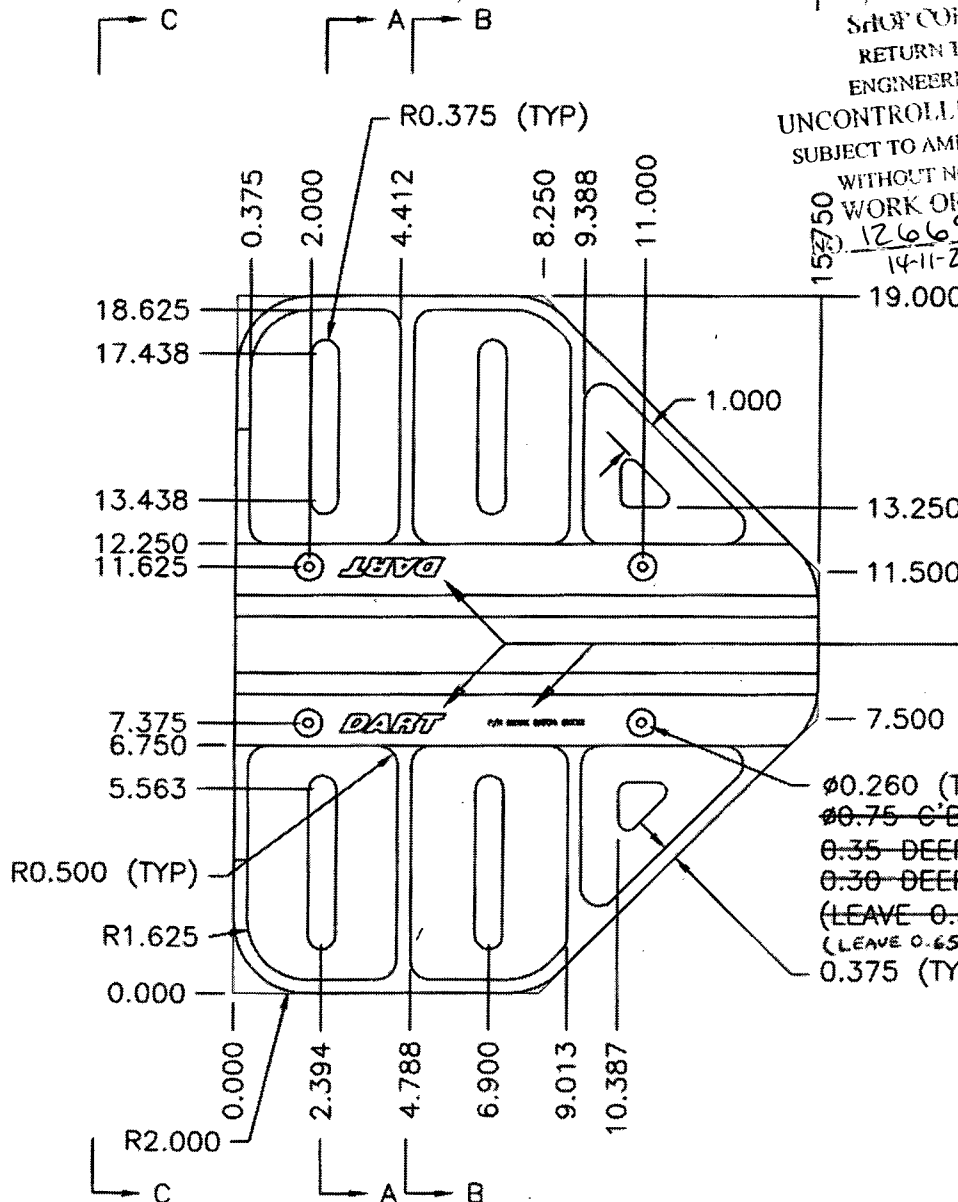
RELEASED
18.06.17 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMMERSBURY, ONTARIO, CANADA	REV. E
KE	KE		
CHECKED WV	APPROVED WV	DRAWING NO. D2435	SHEET 1 OF 2
DATE 98.05.19	TITLE BEARPAW	SCALE 1:5	
A	96.01.24	NEW ISSUE	
B	96.03.26	CHANGE BORE AND C'BORE DEPTH	
C	97.05.07	CHANNEL & C'BORE DEPTH CHANGED	
D	97.10.17	R1.5 BORE WAS R2.637 (TSR A469)	
E	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50	

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

STOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
126698
14-11-24 MLC

E1 02.12.17 0.93 WAS 0.75 REA



MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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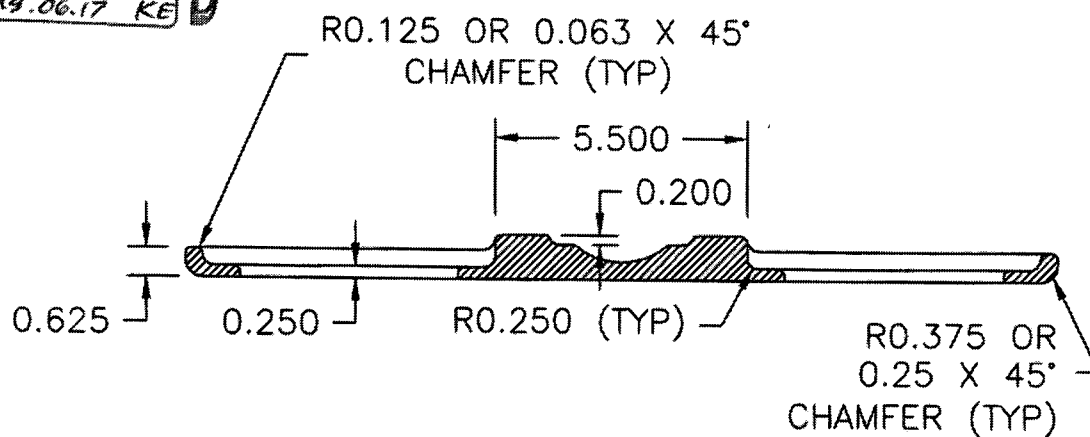
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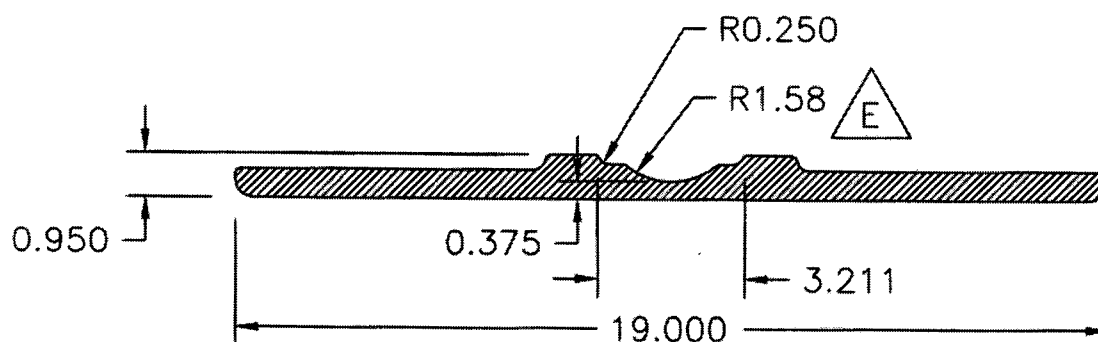


DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>DW</i>	APPROVED <i>KE</i>	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

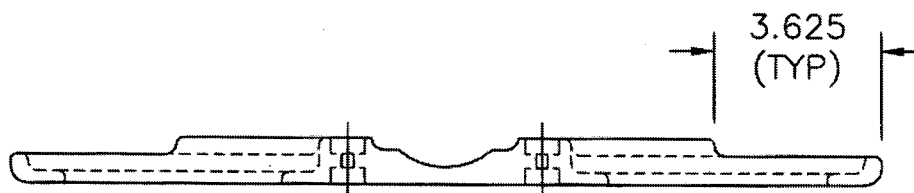
RELEASED
99.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C

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Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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